














Date: Monday, 04/02/2008 1:30:59 PM  
 User: Linda Lacelle


## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 37190	Part Number	: D36623
Estimate Number	: 13155	Drawing Number	: D3662 REV U/R
P.O. Number	:	Project Number	: N/A
This Issue	: 04/02/2008 S.O. No. :	Drawing Revision	: U/R
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 11/02/2008
Previous Run	:	Qty:	20 Um: Each
Written By	: <u>W</u>		
Checked & Approved By	:		
Comment	: Est A 08.02.04 Now turned on Cobra EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R1000	ROUND BAR 1.00"
		
	Comment: Qty.: 0.3266 f(s)/Unit Total: 6.5310 f(s) 6061-T6 round bar 1.00" dia. Batch: <u>M104554</u> J.F. 08/02/06 (19)	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
	Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 J.F. 08/02/06 (19)	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 08/02/06 (19)	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK J.F. 08/02/06 (19)	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>4/6</u> J.F. 08/02/06 (19)	
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		
	Comment: FINAL INSPECTION/W/O RELEASE J.F. 08/02/08 (19)	

Job Completion  2008/2/06 POSITIVE RECALL

EFFECTIVE 08.02.04 AUTH W

LEASED W DATE 08.02.04 Form: rprocess

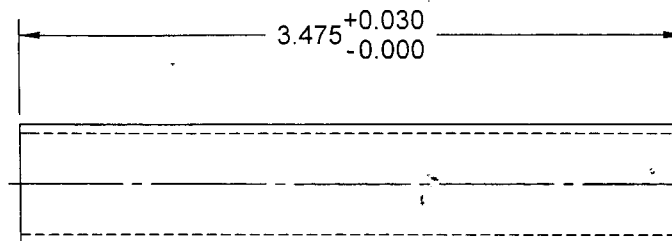
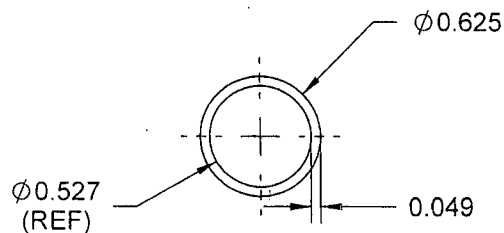
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

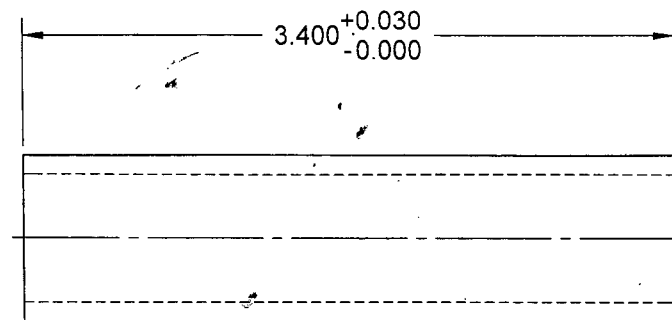
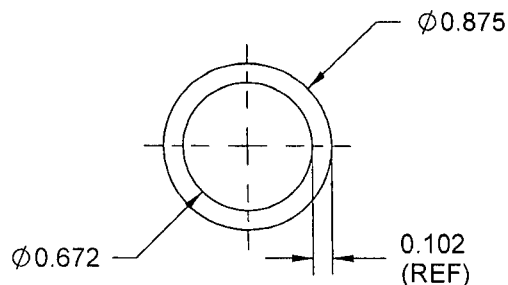
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 28/10/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3662-1 CROSS BOLT SPACER



### D3662-3 CROSS BOLT SPACER

#### NOTES:

##### 1) MATERIAL:

- D3662-1 - ALUMINUM 6061-T6/T62  
TUBING PER WW-T-700/6 OR AMS 4080/4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART MATERIAL SPEC. M6061T6T0.625W0.49)
- D3662-3 - ALUMINUM 6061-T6 (OR 6061-T651/T6510/T6511/T62)  
ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART MATERIAL SPEC. M6061T6RX.XXX)

##### 2) FINISH: NONE

##### 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

##### 4) UNITS: INCHES UNLESS OTHERWISE NOTED

##### 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

##### 6) IDENTIFICATION: NONE

##### 7) WEIGHT: D3662-1 - 0.03 LBS D3662-3 - 0.08 LBS

**PRELIMINARY ISSUE**

A	NEW ISSUE	PH	07.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3662	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CROSS BOLT SPACER	1:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

# FIRST ARTICLE INSPECTION CHECKLIST



## First Article



## Prototype

[illegible]

Measured by:	J.F.
Date:	08/02/06

Audited by:	20
Date:	08/02/06

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

**L Lacle**

**From:** Peter Hum [phum@dartaero.com]  
**Sent:** February 7, 2008 9:18 AM  
**To:** 'L Lacelle'  
**Subject:** RE: D3662-1/-3

Yes you can sign off the positive recall

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** February 7, 2008 9:10 AM  
**To:** 'Peter Hum'  
**Subject:** RE: D3662-1/-3

[illegible]

**From:** Peter Hum [mailto:[phum@dartaero.com](mailto:phum@dartaero.com)]  
**Sent:** February 7, 2008 9:04 AM  
**To:** 'L Lacelle'  
**Subject:** RE: D3662-1/-3

They will be used once we get the STC.

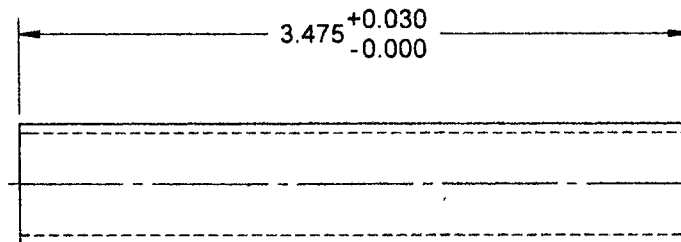
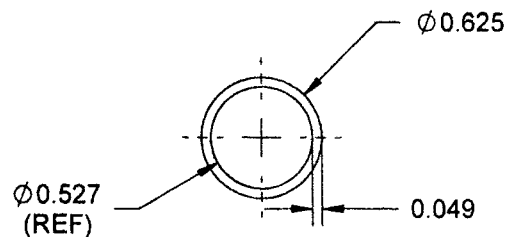
So yes we should keep them in stock.

Peter

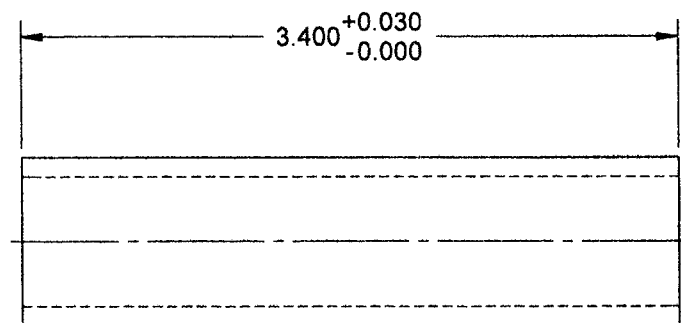
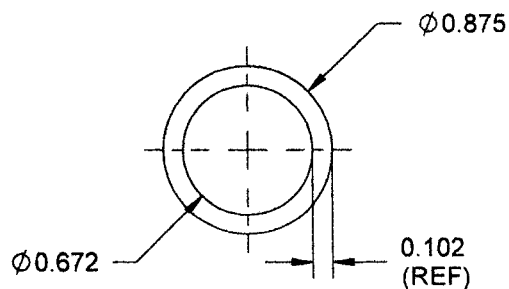
**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** February 7, 2008 9:00 AM  
**To:** Peter Hum (Peter Hum)  
**Subject:** D3662-1/-3

I have 18 of each crossbolt spacers on my desk D3662-1/-3 for the 117 skids. These are still under review, are they any good? Can I sign off the positive recall? Or do you want them upstairs? ?? ?? ??

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd



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##### 6) IDENTIFICATION: NONE

##### 7) WEIGHT: D3662-1 - 0.03 LBS D3662-3 - 0.08 LBS

W10  
37/90  
06.02.03

**RELEASE**  
67.11.22

A	NEW ISSUE	
REV.	DESCRIPTION	
DESIGN	AK	DART AEROSPA PORT HADLC
DRAWN	AK	
CHECKED	b	DRAWING NO. D3662
MFG. APPR.	EE	
APPROVED	M	TITLE CROSS BOLT SPA
DE APPR.	H	
DATE	07.04.20	
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